

# Work Order ID 52514

September 29, 2009 10:47:43 AM



Page 1

Item ID: D3572-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Guide

Start Date: 29/09/2009 Start Qty: 30.00



Cust Item ID:

Required Date: 06/10/2009 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan: *BP*

Date: *09-9-29*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3572

Rev D

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank .500" long

*Y.A 09/10/01*

*30*

*φ*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA685 Rev: *AA* & Dwg D3572 Rev: *C* ☐ 2-Debur  
per dwg D3572

*DIT 09/10/8*

*30*

*φ*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*DIT 09/10/8*

*30*

*φ*

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Page 2

Item ID: D3572-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Guide

Start Date: 29/09/2009 Start Qty: 30.00



Cust Item ID:

Required Date: 06/10/2009 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00



28 09/10/09

30

0

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: CAN

0.00



0.00

Packaging

Memo

Packaging

24/10/09 (30)

150

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

09/10/13  
MF 09-10-09

# Picklist Print

September 29, 2009 10:47:42 AM

Page 1

Work Order ID: 52514



Parent Item: D3572-3RevD



Parent Item Name: Guide

Start Date: 29/09/2009

Required Date: 06/10/2009

Comments:

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No				f	18.6514	1.2006			



6061-T6 Bar .750 X 1.50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

18.6514

110167

18.6514

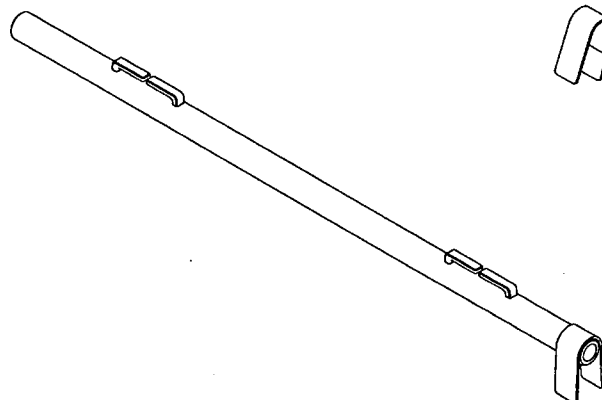
1.375

B.A  
09/10/01

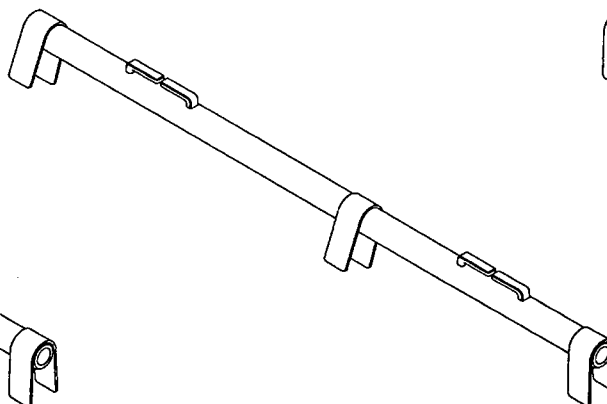


ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

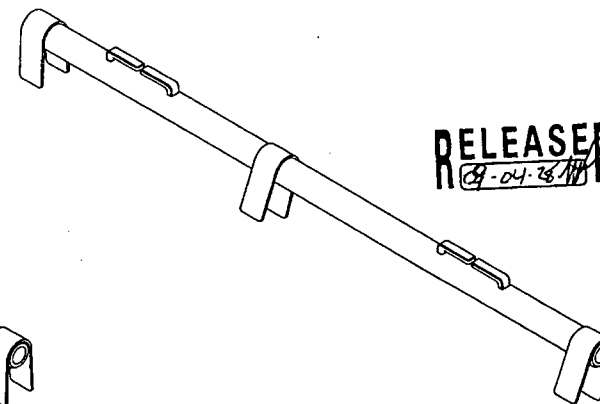
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32514  
31 09-9-29



**D3572-041 GUIDE ASSEMBLY**



**D3572-043 GUIDE ASSEMBLY (UH-1)**



**D3572-044 GUIDE ASSEMBLY (UH-1)**

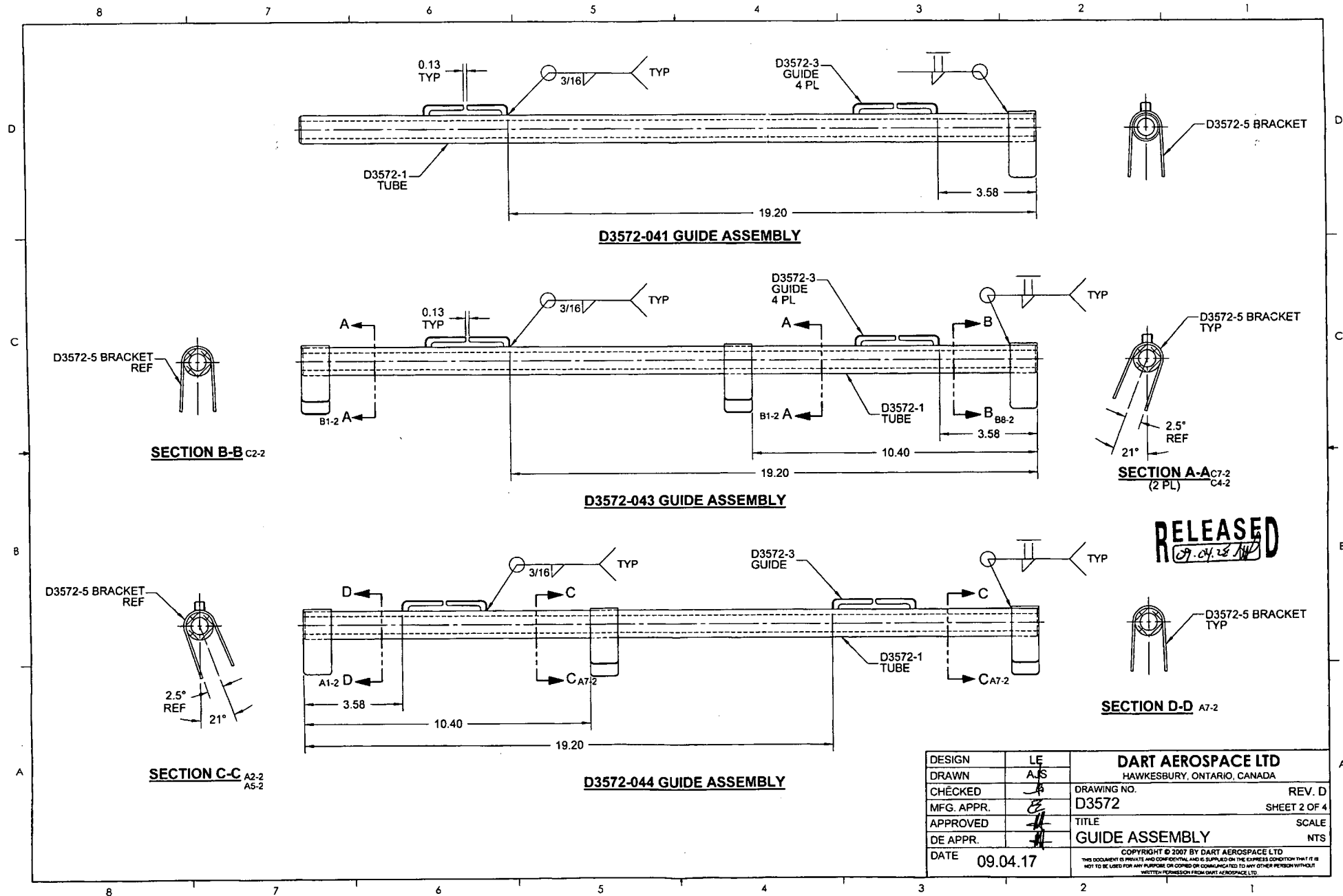
**RELEASED**  
09-04-28

**NOTES:**

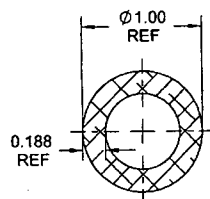
- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs  
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3572	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GUIDE ASSEMBLY	NTS
DATE	09.04.17	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

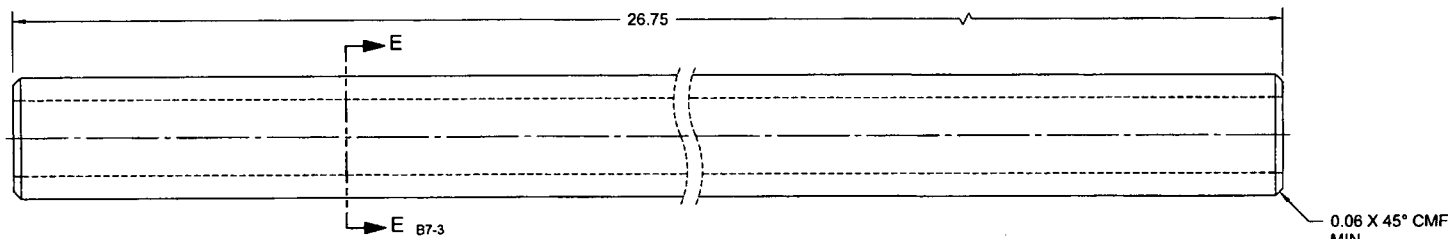
W/10 525141



W/O 52514



**SECTION E-E C5-3**



**D3572-1 TUBE**

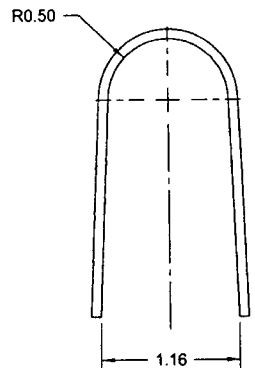
**D3572-1 NOTES:**

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-225/8  
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

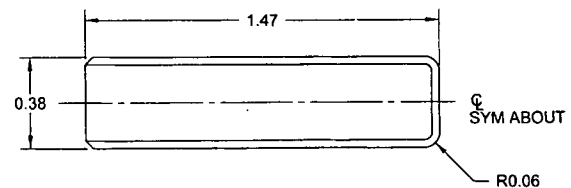
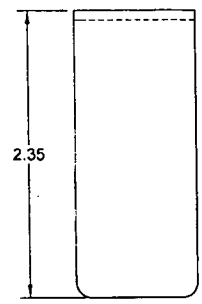
**RELEASED**  
07/04/17

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CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3572	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GUIDE ASSEMBLY	NTS
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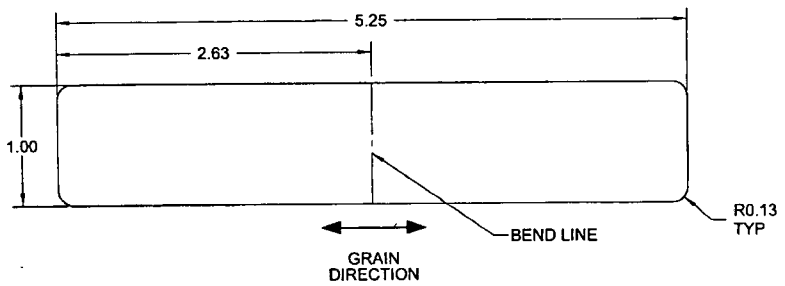
W/0 52514



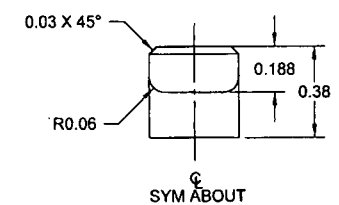
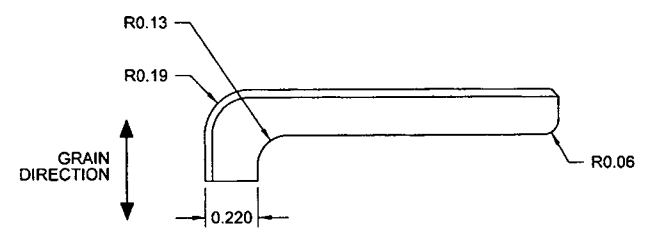
**D3572-5 BRACKET**  
(MAKE FROM D3572-5F)



**D3572-3 GUIDE**



**D3572-5F FLAT PATTERN**



**RELEASED**  
9/10/17

- D3572-3 NOTES:**
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
AMS-QQ-A-200/8 (OR AMS4160)  
REF DART SPEC M6061T6B
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.01 lbs

- D3572-5 NOTES:**
- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M60601T6S.080
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.04 lbs

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MFG. APPR.	J	<b>D3572</b>	SHEET 4 OF 4
APPROVED	J	TITLE	SCALE
DE APPR.	J	<b>GUIDE ASSEMBLY</b>	NTS
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